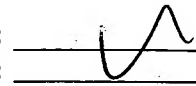
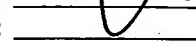


*Reprint - 213*

Date: Monday, 05/11/2007 2:29:58 PM  
User: Linda Lacelle

Process Sheet

|                                    |                                                                                                                                      |                           |                   |
|------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------|---------------------------|-------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services                                                                                                  | <b>Drawing Name</b> :     | MID TUBE ASSEMBLY |
| <b>Job Number</b> :                | 33636                                                                                                                                |                           |                   |
| <b>Estimate Number</b> :           | 10469                                                                                                                                |                           |                   |
| <b>P.O. Number</b> :               | N/A                                                                                                                                  | <b>Part Number</b> :      | D3391013          |
| <b>This Issue</b> :                | 05/11/2007                                                                                                                           | <b>S.O. No.</b> :         | N/A               |
| <b>Prsht Rev.</b> :                | NC                                                                                                                                   | <b>Drawing Number</b> :   | D3391 REV F       |
| <b>First Issue</b> :               | 19/07/2007                                                                                                                           | <b>Project Number</b> :   | N/A               |
| <b>Previous Run</b> :              | 32239                                                                                                                                | <b>Drawing Revision</b> : | F                 |
| <b>Written By</b> :                |                                                     | <b>Material</b> :         | N/A               |
| <b>Checked &amp; Approved By</b> : |                                                     | <b>Due Date</b> :         | 30/07/2007        |
| <b>Comment</b> :                   | Est. A 05.10.20 New Issue KJ/EC<br>Est. B 06.02.10 ECN773 dwg rev.D EC<br>Est C 07.03.20 rev F dwg EC<br>Est D 07.03.28 re-format EC |                           |                   |
| <b>Type</b> :                      | LANDING GEAR                                                                                                                         |                           |                   |
| <b>Qty:</b>                        | 1                                                                                                                                    | <b>Um:</b>                | Each              |

Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | D25001100 | Skidtube Extrusion |
|-----|-----------|--------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

|     |             |             |       |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
| 1   | D2500-1-100 | Extrusion   |       |

*See attached pg 1*

|     |          |                   |
|-----|----------|-------------------|
| 2.0 | D3391011 | Fwd Tube Assembly |
|-----|----------|-------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch:

|     |                |                         |
|-----|----------------|-------------------------|
| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391 ✓

2-Identify as D3391-023 ✓

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391 ✓

4-Open float bag holes 0.257" as per Dwg D3391 ✓

5-C'sink float bag holes as per Dwg D3391 ✓

6-Open remaining holes to Ø0.375" except for fwd saddle hole of detail "J" ✓

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 05/11/2007 2:29:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Remove .030" from Fwd indexing Ridge as per Dwg D3391 ✓

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391 ✓

9-Deburr ✓

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker, ✓

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J" ✓

12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.257" and c'sink (20 holes) as per Dwg D3391 ✓

13-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\* ✓

14-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

15- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

16- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

17- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

18- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

19- Open 12 wearplate holes in D3391-021 to 0.257" dia. & c'sink per dwg.

20-Deburr and blow out all chips from inside tube

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes including "B" holes using DT8796 as per Dwg D3391

3-Open float bag holes as per Dwg D3391

4-C'sink float bag holes as per Dwg D3391

7-11-5

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 05/11/2007 2:29:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 5-Open remaining holes as per dwg D3391
- 6- Locate electric step holes 41.0000" from fwd end and drill using DT 8393  
\*\*\*\*\* ensure step holes are on top of tube not bottom Pat\*\*\*\*\*
- 7- Open electric step holes 0.332" per dwg D3391 (section L-L)
- 8- Open electric step holes 0.250" per dwg D3391 (section M-M)
- 9- Open electric step holes 0.250" per dwg D3391 (section LL-LL)
- 10-Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 11-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 12-Deburr
- 13-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.208" holes with paint marker
- 14-Open wearplate holes of D3391-013 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391
- 15-Open wearplate holes of D3391-013 assembly detail section H-H to Ø0.257" and c/sink (20 holes) as per Dwg D3391
- 16-Open .375" holes to .438"
- 17- insert D3391-011 and clico in place with wearplate holes, transfer drill saddle holes as per dwg D3391.
- 19-Deburr and blow out all chips from inside tube

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5-0710/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11

7-11-6

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 05/11/2007 2:29:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07/11/06

8.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

1621827 B33657

A/R

Sikaflex-241/-291

M105488

Sikaflex expire date:

7-7-1

Start: 7-11-6 Time: 10:50

Finish: 07/11/07 Time: 6:00 AM

u 7-11-6

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

2-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

u 7-11-6

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

G: 07/11/07

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PRESSURE WASH  
M105914

07/11/07  
BR 07-11-07

BR 07/11-07

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/11/07

13.0

NAS1330C3KB116

Insert



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

M104575

FL 07/11/07

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Monday, 05/11/2007 2:29:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

NAS1330C3KB166

INSERT



*NAS1330C3KB166*



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

*m103954*

*FL*

15.0

NAS1329C4KB140

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PHENOLIC WASHER

batch:

*m104652*

*FL*

16.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PHENOLIC WASHER

batch:

*m105116*

*FL*

17.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch:

*m105143*

*FL*

18.0

NAS1515H4L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch:

*m105408*

*FL*

19.0

AN960C416L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch:

*m100651*

*FL*

20.0

MS27039C109

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch:

*m17831*

*FL 07/11/07*

*1*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/10/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 05/11/2007 2:29:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS27039C408

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

batch: M/7831

FL

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Assemble as per dwg D3391

FL 07/11/07 ①

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

W/0 32523A

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/0 32523A

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
H 07/11/07

Job Completion



W 07.11.07

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

*# -013*

Date: Thursday, 7/19/2007 2:21:36 PM  
User: Kim Johnston

**Process Sheet**

|                       |                                                                                                                                        |                  |                             |
|-----------------------|----------------------------------------------------------------------------------------------------------------------------------------|------------------|-----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                                                                                                  | Drawing Name     | : MID TUBE ASSEMBLY         |
| Job Number            | : 33636                                                                                                                                |                  |                             |
| Estimate Number       | : 10469                                                                                                                                |                  |                             |
| P.O. Number           | :                                                                                                                                      | Part Number      | : D3391023 <i>-013</i>      |
| This Issue            | : 7/19/2007 S.O. No. :                                                                                                                 | Drawing Number   | : D3391 REV F               |
| Prsht Rev.            | : NC                                                                                                                                   | Project Number   | : N/A                       |
| First Issue           | : 1 / Type : LANDING GEAR                                                                                                              | Drawing Revision | : F                         |
| Previous Run          | : 32239                                                                                                                                | Material         | :                           |
| Written By            | :                                                                                                                                      | Due Date         | : 7/30/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <i>[Signature]</i>                                                                                                                   |                  |                             |
| Comment               | : Est. A 06.10.20 New Issue KJ/EC<br>Est. B 06.02.10 ECN773 dwg rev.D EC<br>est C 07.03.20 rev F dwg EC<br>est D 07.03.28 re-format EC |                  |                             |

**Additional Product**

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1 0 | D25001100 | Skidtube Extrusion |
|-----|-----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 1   | D2500-1-100 | Extrusion   | <i>B24593</i> |

*DP 7-7-25*

|     |          |                   |
|-----|----------|-------------------|
| 2 0 | D3391021 | Fwd Tube Assembly |
|-----|----------|-------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: *33635*

*DP 7-11-6*

|     |                |                         |
|-----|----------------|-------------------------|
| 3 0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open float bag holes 0.257" as per Dwg D3391

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375" except for fwd saddle hole of detail "J"

*DP 7-7-25*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 7/19/2007 2:21:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 7-Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 9-Deburr
- 10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,
- 11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"
- 12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.257" and c'sink (20 holes) as per Dwg D3391
- 13-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*
- 14-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)
- 15- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021
- 16- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.
- 17- Locating from two fwd wearplate holes drillol remaining 6 wearplte holes in D3391-021 using DT8937
- 18- Open 2 fwd wearplate holes in D3391-023 to .250" dia.
- 19- Open 12 wearplate holes in D3391-021 to 0.257" dia. & c'sink per dwg.
- 20-Deburr and blow out all chips from inside tube

40

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Date: Thursday, 7/19/2007 2:21:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

A/R

Sikaflex-241/-291

Sikaflex expire date:

Start: \_\_\_\_\_ Time: \_\_\_\_\_

Finish: \_\_\_\_\_ Time: \_\_\_\_\_

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

2-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:21:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 33636

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per dwg D3391

touch-up holes in D3391-021 with alodine

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



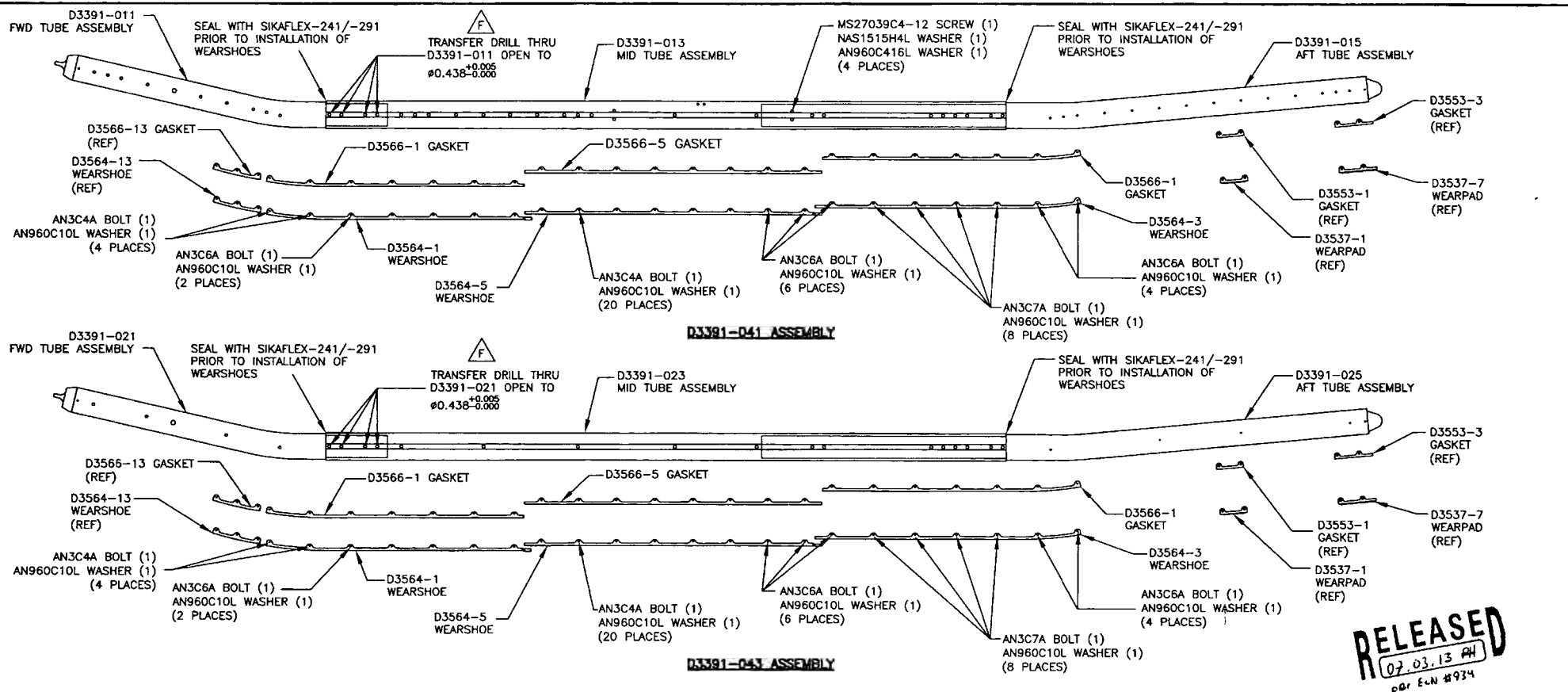
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# **D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

| QTY -041 | QTY -043 | PART NUMBER  | DESCRIPTION             |
|----------|----------|--------------|-------------------------|
| X        | X        | D3391-041    | FLOAT SKIDTUBE ASSEMBLY |
|          |          | D3391-043    | FLOAT SKIDTUBE ASSEMBLY |
| 1        |          | D3391-011    | FWD TUBE ASSEMBLY       |
| 1        |          | D3391-013    | MID TUBE ASSEMBLY       |
| 1        |          | D3391-015    | AFT TUBE ASSEMBLY       |
| 1        | 1        | D3391-021    | FWD TUBE ASSEMBLY       |
| 1        | 1        | D3391-023    | MID TUBE ASSEMBLY       |
| 1        | 1        | D3391-025    | AFT TUBE ASSEMBLY       |
| 1        | 1        | D3564-1      | WEARSHOE                |
| 1        | 1        | D3564-3      | WEARSHOE                |
| 1        | 1        | D3564-5      | WEARSHOE                |
| 2        | 2        | D3566-1      | GASKET                  |
| 1        | 1        | D3566-5      | GASKET                  |
| 24       | 24       | AN3C4A       | BOLT                    |
| 12       | 12       | AN3C6A       | BOLT                    |
| 8        | 8        | AN3C7A       | BOLT                    |
| 44       | 44       | AN960C10L    | WASHER                  |
| 4        | 4        | MS27039C4-12 | SCREW                   |
| 4        | 4        | NAS1515H4L   | WASHER                  |
| 4        | 4        | AN960C416L   | WASHER                  |

## **GENERAL NOTES**

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DTB217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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|         |          |                                                             |
|---------|----------|-------------------------------------------------------------|
| F       | 07.01.18 | ADD SS WEARSHOE, GASKET<br>REMOVE FWD SADDLE HOLE -011/-021 |
| E       | 06.04.25 | CHANGE TOLERANCE, EASE MANUFACTURE                          |
| D       | 06.01.23 | UPDATE TOLERANCE, CHANGE HOLE SIZE                          |
| C       | 05.09.27 | LENGTHEN AFT EXTENSION                                      |
| B       | 05.06.10 | DRAWING UPDATES                                             |
| A       | 05.02.07 | NEW ISSUE                                                   |
| DESIGN  | PH       | DRAWN BY PH                                                 |
| CHECKED | #        | APPROVED                                                    |
| DATE    | 07.01.18 | TITLE                                                       |
|         |          | 412 FLOAT SKIDTUBE                                          |
|         |          | SCALE                                                       |
|         |          | NTS                                                         |

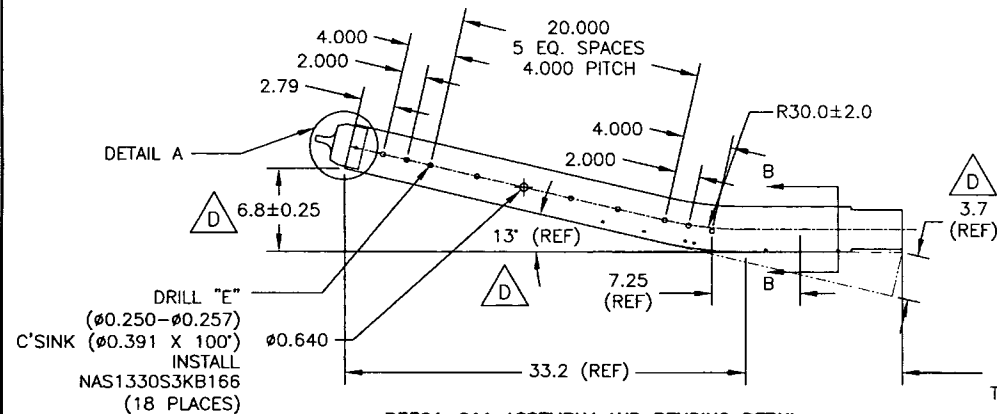
**DART** DART Aerospace USA, Inc.  
PORT HADLOCK, MA

DRAWING NO. D3391  
REV. F  
SHEET 1 OF 5

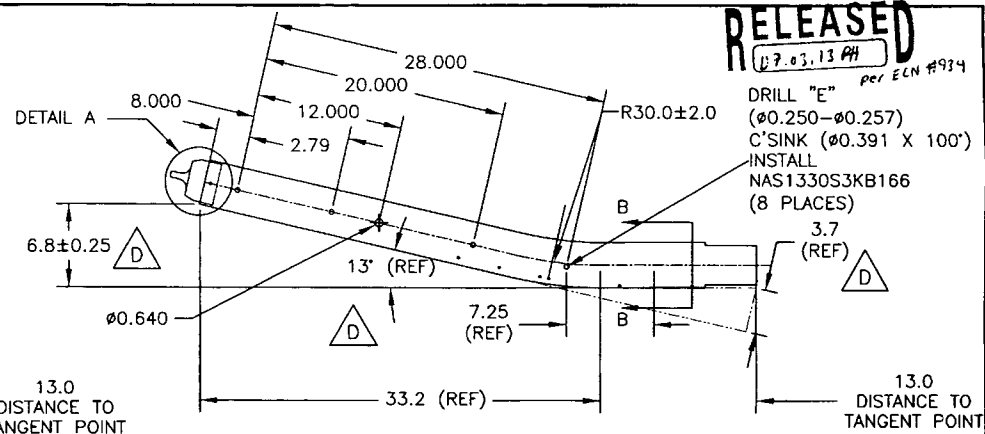
NO. 336058  
SUBMITTER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

**RELEASED**  
07.03.13 PH  
per E-LN #934

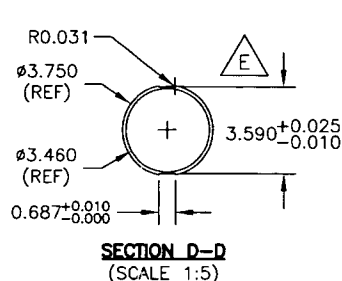
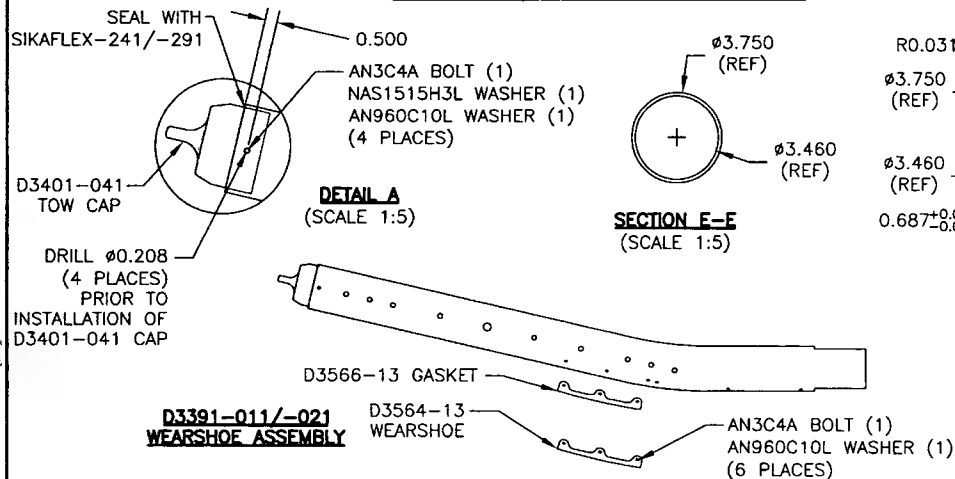
**RELEASED**  
 07.03.13 AH  
 per EEN #974



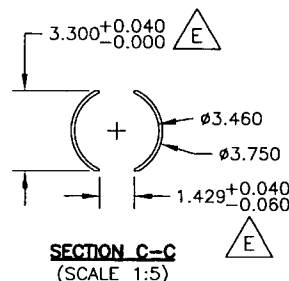
**D3391-011 ASSEMBLY AND BENDING DETAIL**



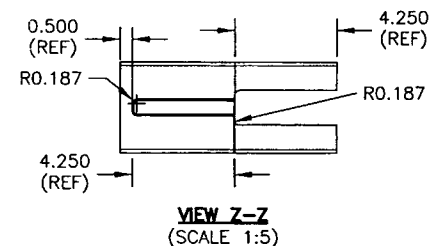
**D3391-021 ASSEMBLY AND BENDING DETAIL**



**SECTION D-D (SCALE 1:5)**



**SECTION C-C (SCALE 1:5)**



**VIEW Z-Z (SCALE 1:5)**

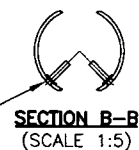
**D3391-011/-021 WEARSHOE ASSEMBLY**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

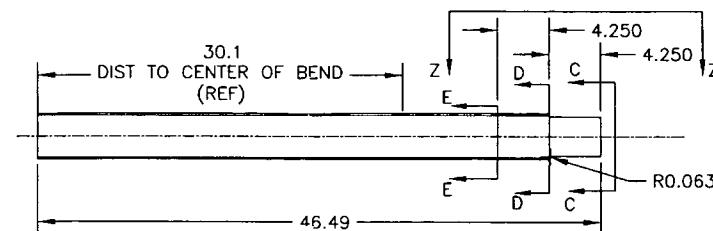
| QTY - 011 | QTY - 021 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         | X         | D3391-011      | FWD TUBE ASSEMBLY          |
|           |           | D3391-021      | FWD TUBE ASSEMBLY          |
| 1         | 1         | D6013-047      | FWD TUBE                   |
| 1         | 1         | D3401-041      | TOW CAP                    |
| 1         | 1         | D3564-13       | WEARSHOE                   |
| 1         | 1         | D3566-13       | GASKET                     |
| 10        | 10        | AN3C4A         | BOLT                       |
| 4         | 4         | NAS1515H3L     | WASHER                     |
| 10        | 10        | AN960C10L      | WASHER                     |
| 30        | 20        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |

UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 330026

DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100')  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)



**SECTION B-B (SCALE 1:5)**



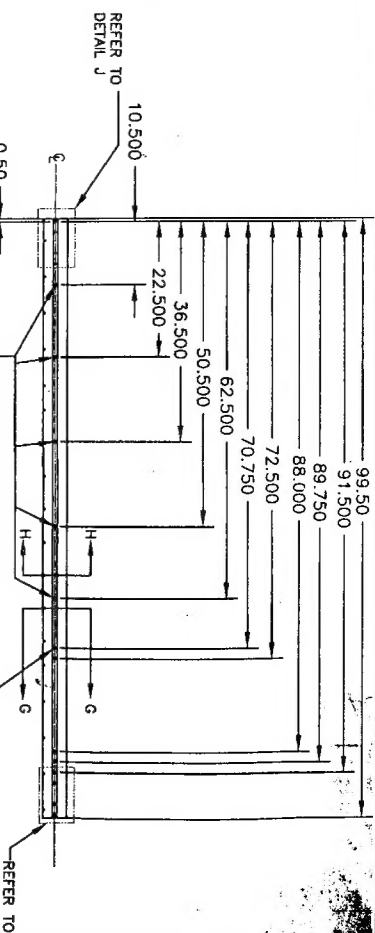
**D3391-1 DRILLING AND CUTTING DETAIL  
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)**

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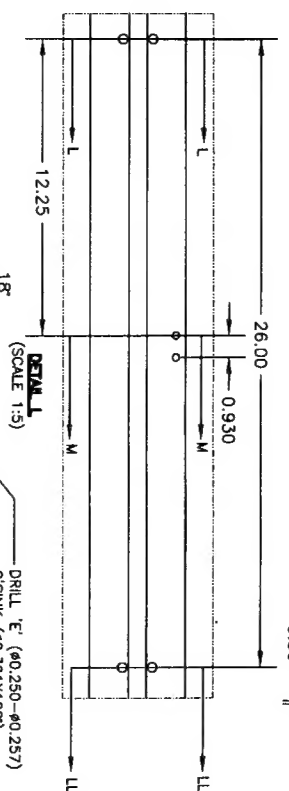
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|----------|----------|--------------------|--------------------------|
| PH       | PH       |                    | PORT HADLOCK, MA         |
| CHECKED  | APPROVED | DRAWING NO.        | REV. F                   |
|          |          | D3391              | SHEET 2 OF 5             |
| DATE     |          | TITLE              | SCALE                    |
| 07.01.18 |          | 412 FLOAT SKIDTUBE | 1:10                     |

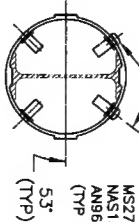




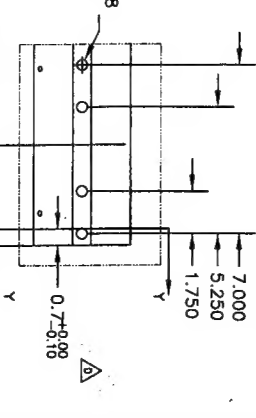
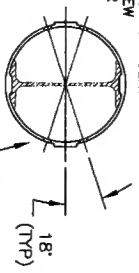
**03361-023 ASSEMBLY DETAIL**



**SECTION M-1**  
(SCALE 1:4)



**SECTION 11-11**  
**(SCALE 1:4)**



SECTION 1-1  
(SCALE 1:4)

REMOVE 0.030  
FROM TOP AND BOTTOM  
TO 3.610

WORK ORDER  
WITHOUT NOT  
SUBJECT TO AMEND  
UNCONTROLLED  
ENGINEERING  
RETURN TO  
SHOP COPY

7

D33891-013/-023 MID TUBE ASSEMBLY

1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKATLEX-241/-291 PER OSI 015

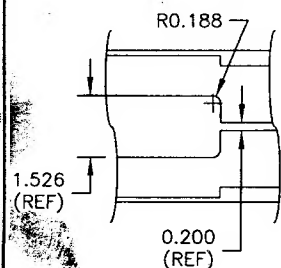
**SECTION X-X**  
(SCALE 1:2)

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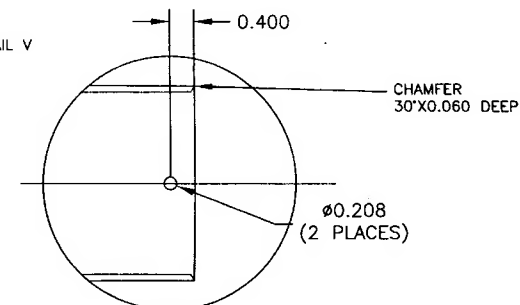
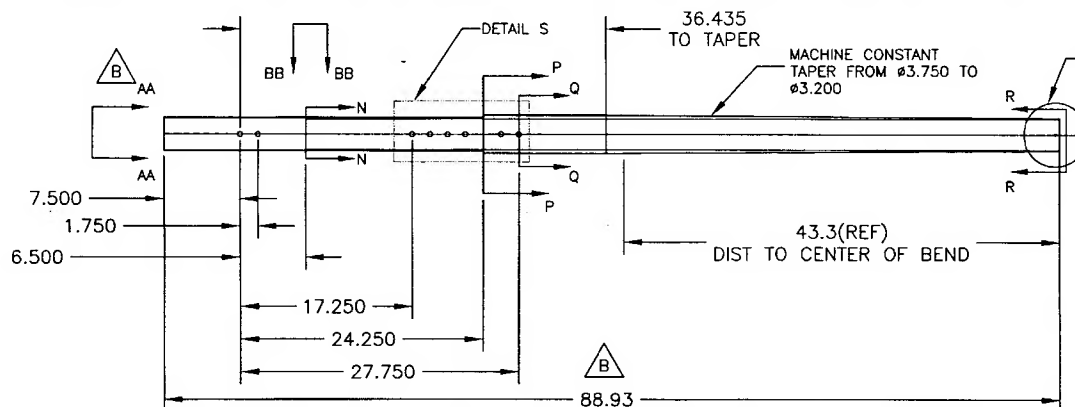
|               |                    |                                                                                                                                                                       |
|---------------|--------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| DESIGN        | DRAWN BY           |  <b>DAVT</b><br>DART AEROSPACE USA, INC.<br><small>DART HEADQUARTERS, INC.</small> |
| <i>PH</i>     | <i>PH</i>          |                                                                                                                                                                       |
| CHECKED       | APPROVED           | DRAWING NO.                                                                                                                                                           |
| <del>PH</del> | <del>PH</del>      | D3391                                                                                                                                                                 |
| DATE          | TITLE              | REV. 1<br>SHEET 3 OF 5                                                                                                                                                |
| 07.01.18      | 412 FLOAT SKIDTUBE | SCALE<br>1:20                                                                                                                                                         |

RELEASED  
07.05.13 AH  
REF ID: A66934



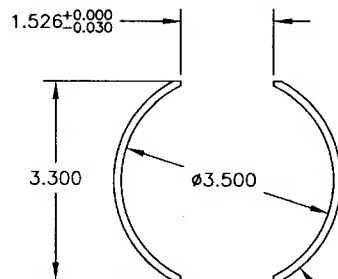


VIEW BB-BB  
(SCALE 1:3)

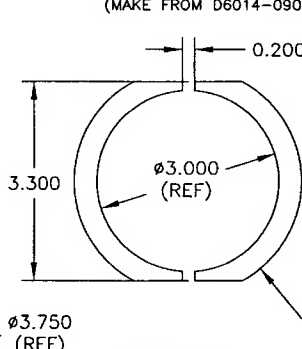


DETAIL V  
(SCALE 1:2)

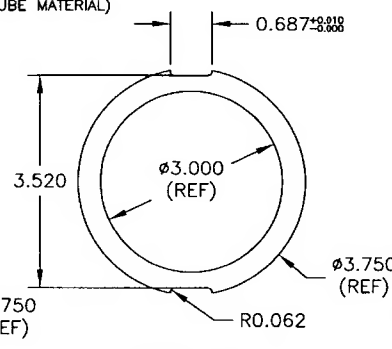
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



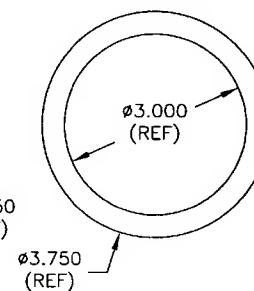
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(SCALE 1:2)



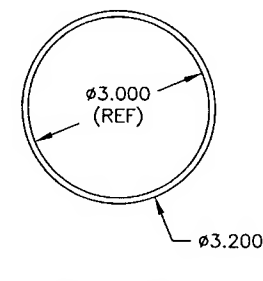
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(SCALE 1:2)



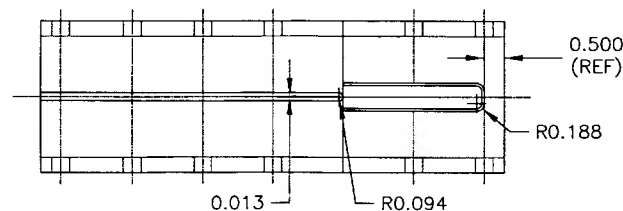
SECTION P-P  
(SCALE 1:2)



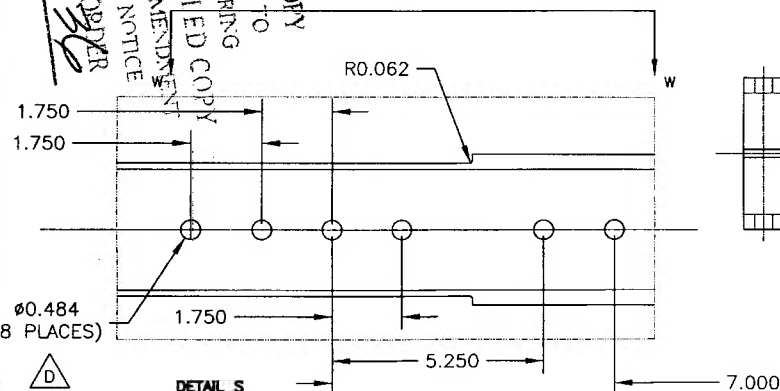
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



VIEW W-W  
(SCALE 1:3)



DETAIL S  
(SCALE 1:3)

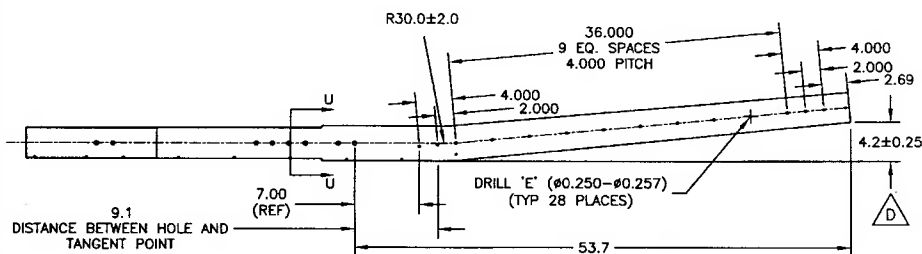
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RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

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07.05.13 PH  
per ESN #934

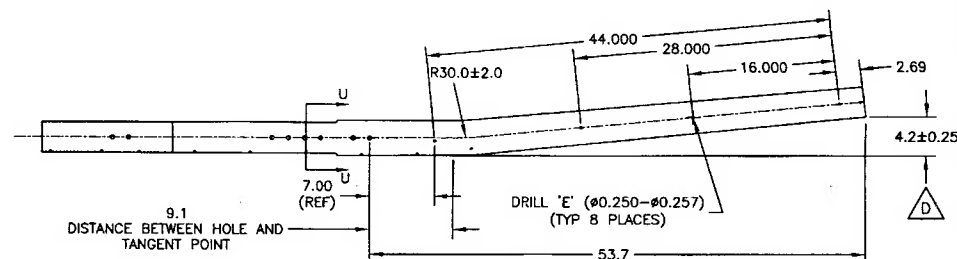
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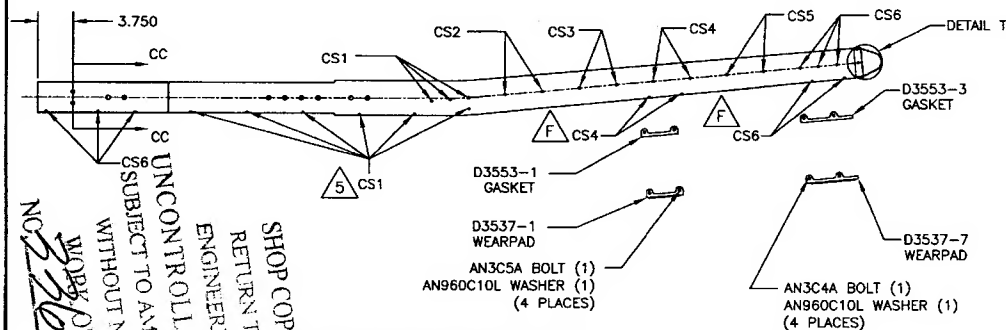
|                  |                             |                                                          |              |
|------------------|-----------------------------|----------------------------------------------------------|--------------|
| DESIGN<br>PH     | DRAWN BY<br>PH              | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT HADLOCK, MA | REV. F       |
| CHECKED<br>#     | APPROVED<br>#               | DRAWING NO.<br>D3391                                     | SHEET 4 OF 5 |
| DATE<br>07.01.18 | TITLE<br>412 FLOAT SKIDTUBE | SCALE<br>1:12                                            |              |



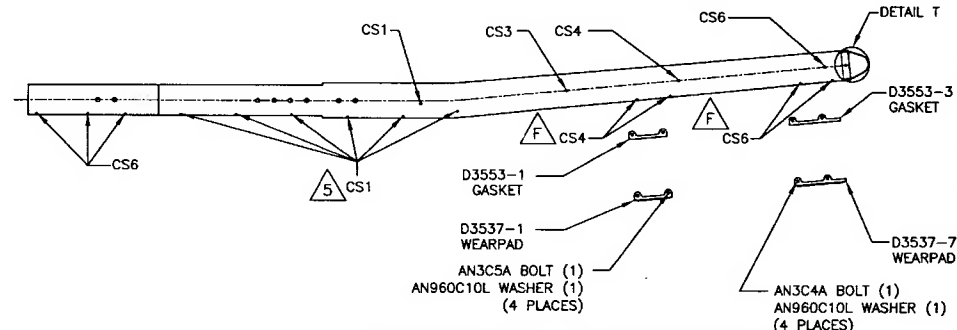
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



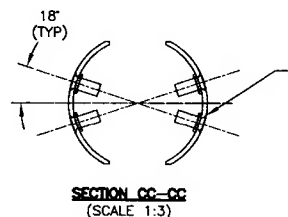
**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

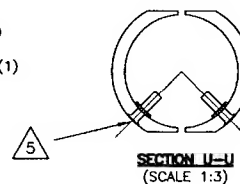
**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

| QTY - 015 | QTY - 025 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         | X         | D3391-015      | AFT TUBE ASSEMBLY          |
|           |           | D3391-025      | AFT TUBE ASSEMBLY          |
| 1         | 1         | D6014-090      | AFT TUBE                   |
| 1         | 1         | D2646          | AFT CAP                    |
| 1         | 1         | D3537-1        | WEARPAD                    |
| 1         | 1         | D3537-7        | WEARPAD                    |
| 1         | 1         | D3553-1        | GASKET                     |
| 1         | 1         | D3553-3        | GASKET                     |
| 18        | 14        | NAS1330S3KB366 | INSERT (OR AES10KB366)     |
| 4         | 2         | NAS1330S3KB316 | INSERT (OR NAS1330C3KB316) |
| 8         | 6         | NAS1330S3KB266 | INSERT (OR NAS1330C3KB266) |
| 4         |           | NAS1330S3KB216 | INSERT (OR NAS1330C3KB216) |
| 16        | 12        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4         |           | NAS1330S4KB151 | INSERT (OR NAS1330C4KB151) |
| 6         | 6         | AN3C5A         | BOLT                       |
| 4         | 4         | AN3C5A         | BOLT                       |
| 2         | 2         | NAS1515H3L     | WASHER                     |
| 10        | 10        | AN960C10L      | WASHER                     |

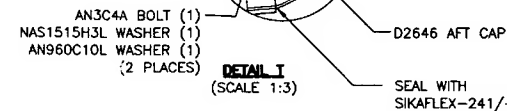


**SECTION CC-CC**  
(SCALE 1:3)

DRILL 'Q' (Ø0.332-Ø0.338)  
C'SINK (Ø0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



**SECTION U-U**  
(SCALE 1:3)



**DETAIL T**  
(SCALE 1:3)

**RELEASED**  
07.03.13 RH  
per ECU #934

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N            |
|--------------|---------------|---------------|--------|----------------|
| CS1          | 18            | 14            | Ø0.425 | NAS1330S3KB366 |
| CS2          | 4             |               | Ø0.391 | NAS1330S3KB366 |
| CS3          | 4             | 2             | Ø0.391 | NAS1330S3KB316 |
| CS4          | 8             | 6             | Ø0.391 | NAS1330S3KB266 |
| CS5          | 4             |               | Ø0.391 | NAS1330S3KB216 |
| CS6          | 16            | 12            | Ø0.391 | NAS1330S3KB166 |

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| CHECKED<br>H     | APPROVED<br>H               | DRAWING NO.<br>D3391                                     |
| DATE<br>07.01.18 | TITLE<br>412 FLOAT SKIDTUBE | REV. F<br>SHEET 5 OF 5<br>SCALE<br>1:12                  |

